

Work Order ID 63966



Page 1

Monday, November 22, 2010 10:29:59 AM

Item ID: D3571-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Guide

Start Date: 11/22/2010 Start Qty: 10.00



Cust Item ID:

Required Date: 11/30/2010 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan:

AK

Date: *10-11-22*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3571	Rev A								
100	BAND SAW	0.00				10	0		
Bandsaw	Memo	0.00							
Jeaspa Bandsaw	Cut blank 2.90 " long								
110	HAAS CNC VERTICAL MACHINING #1	0.00				10	0		
HAAS 1	Memo	0.00							
HAAS CNC vertical machine #1	1- Mill as per Folio FA681 Rev: <i>AA</i> & Dwg D3571 Rev: <i>A</i> <input type="checkbox"/> 2-Deburr per dwg D3571								
120	QC2- Inspect parts off machine FAI/FAIB	0.00				10	0		
QC	Memo	0.00							
Quality Control									

B.A. 10/12/21

B.A. 10/12/21

B.A. 10/12/21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 63966

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Page 2

Item ID: D3571-3

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Item Name: Guide

Start Date: 11/22/2010 Start Qty: 10.00



Cust Item ID:

Required Date: 11/30/2010 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC8- Inspect parts - second check

0.00

ent 10/12/22



QC

Memo

0.00

10

0

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

10 BL 10-12-23.

Hand Finishing

150

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00



Powdercoat

Memo

0.00

10 BL 10-12-23.

Powder Coating

M1125488

START TIME:

10:15

OVEN TEMPERATURE:

320 FINISH TIME:

10:45

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Work Order ID 63966

Monday, November 22, 2010 10:29:59 AM



Page 3

Item ID: D3571-3

Accept



Setup Start



Revision I:

Item Name: Guide

Stop



Start Date: 11/22/2010 Start Qty: 10.00



Cust Item ID:

Required Date: 11/30/2010 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00		2) 24 10/01/03		10	4		
170 Packaging Packaging	Identify as per dwg & Stock Location: 240 Memo	0.00 0.00							10/01/03 (12)
180 QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							CK 11/01/03 CQ 11/01/03

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NOTE: Date & initial all entries

Picklist Print

Monday, November 22, 2010 10:30:03 AM

Page 1

Work Order ID: 63966

Parent Item: D3571-3

Parent Item Name: Guide



Start Date: 11/22/2010

Required Date: 11/30/2010

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:A New Issue 07-02-01 JLM
IPP Rev:B Remove manual Machinig 08-05-26 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B0.750X01.50 0		Purchased	No			110	f	23.0000	0.241	2.536842			



6061-T6 Bar .750 X 1.50



Location

Loc Qty

Loc Code

MAT

20

(9) ✓ 116135

20

MAT028

3

114968

3

(1) -116405

2.2824^{ft}

B.A 10/12/21

0.2536^{ft}

B.A 10/12/21

W/O:		WORK ORDER CHANGES					
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DART AEROSPACE LTD		Work Order:	43964
Description: Guide		Part Number:	D3571-3
Inspection Dwg: D3571 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.698	+/-0.010	0.699	✓		Vecn	GA-01
2.75	+/-0.030	2.752	✓		"	"
1.38	+/-0.030	1.375	✓		"	"
1.25	+/-0.030	1.249	✓		"	"
0.63	+/-0.010	0.624	✓		"	"
0.031 chamfer	+/-0.010	0.032	✓		"	"
Ø0.500	+0.006/-0.001	Ø0.501	✓		"	"
Ø0.201	+0.005/-0.001	Ø0.202	✓		"	"
R0.25	+/-0.030	R0.250	✓		R-6	ref.
0.260	+0.000/-0.010	0.256	✓		Vecn	GA-01
Ø0.385 x 100°	+0.006/-0.001 x 0.5°	Ø0.386 x 100°	✓		"	"
0.125	+/-0.010	0.126	✓		"	"
2.250	+/-0.010	2.247	✓		"	"
0.250	+/-0.010	0.252	✓		"	"
0.188	+/-0.010	0.190	✓		"	"
0.063 chamfer	+/-0.010	0.063	✓		"	"

Measured by:	A.A	Audited by:	[Signature]	Prototype Approval:	N/A
Date:	10/12/21	Date:	10/12/22	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.04.16	New Issue	KJ/JLM	[Signature]

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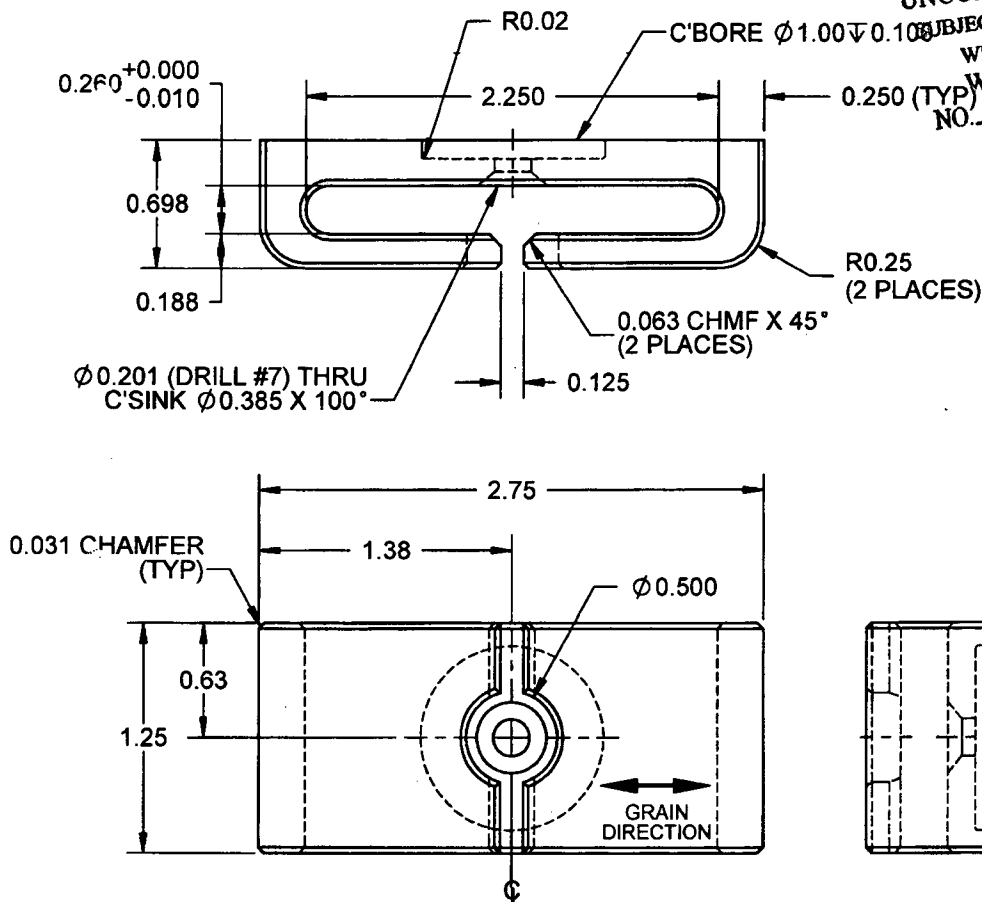
NOTE: Date & initial all entries

DART

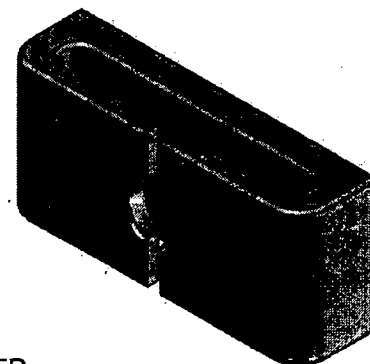
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CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3571	REV. A SHEET 1 OF 2
DATE 07.01.29	TITLE GUIDE		SCALE 1:1
REV A	DATE 07.01.29	DESCRIPTION NEW ISSUE	

RELEASED07.04.12 *[Signature]*

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *63966*
PH 10-15-22

**D3571-1 GUIDE****NOTES:**

- 1) MATERIAL: 6061-T6 (OR T651/T6510/T6511/T62) ALUMINUM BAR
PER QQ-A-225/8 OR AMS 4117/4128/4115/4116
OR QQ-A-200/8 OR AMS 4160 (REF DART SPEC M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GRAY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3571-1" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) PART IS SYMMETRIC ABOUT ϕ

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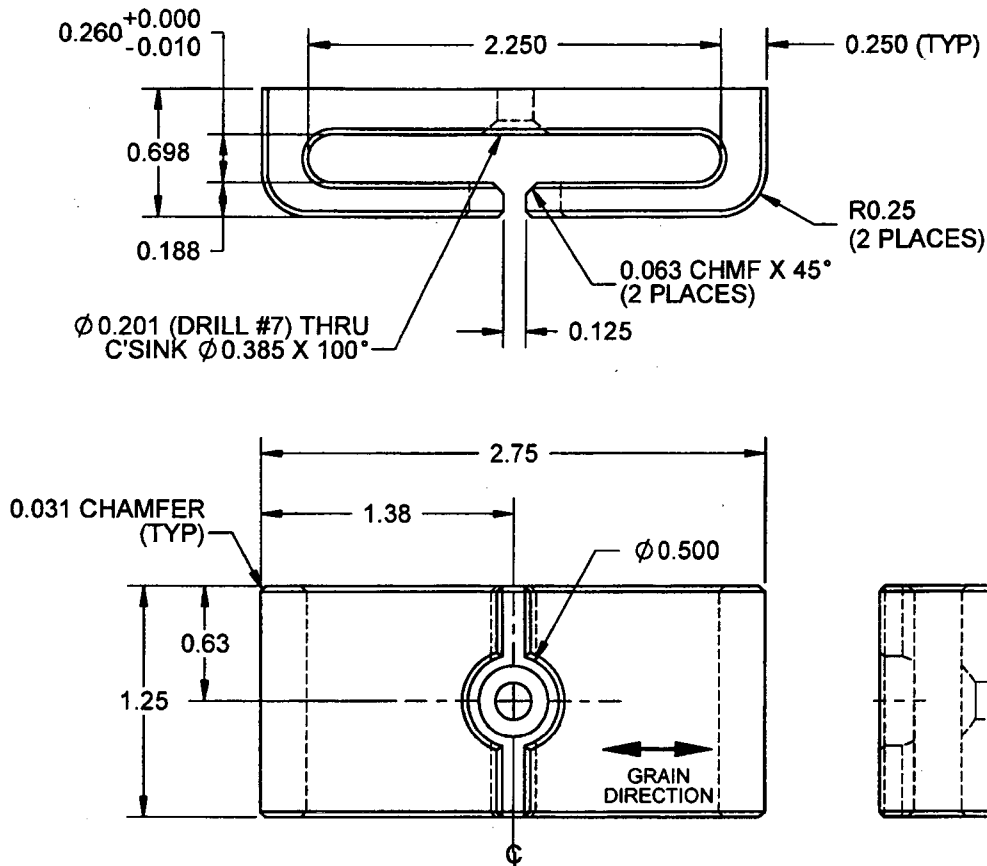
NOTE: Date & initial all entries

DART

DESIGN <i>LE</i>	DRAWN BY <i>LE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3571	REV. A SHEET 2 OF 2
DATE 07.01.29	TITLE GUIDE		SCALE 1:1

RELEASED
07.04.12 *[Signature]*

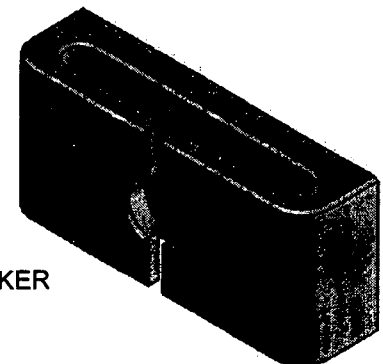
WLO 639 66



D3571-3 GUIDE

NOTES:

- 1) MATERIAL: 6061-T6 (OR T651/T6510/T6511/T62) ALUMINUM BAR
PER QQ-A-225/8 OR AMS 4117/4128/4115/4116
OR QQ-A-200/8 OR AMS 4160 (REF DART SPEC M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
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- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3571-3" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) PART IS SYMMETRIC ABOUT ϕ



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